



54272 DeRev.

Work Order ID 53924



Page 1

November 23, 2009 2:50:54 PM

Item ID: D2841-042

Accept



Setup Start



Revision ID: B

Stop



Item Name: Step Assembly RH, 206 Float



Cust Item ID:

Start Date: 23/11/2009 Start Qty: 2.00

Customer:



Required Date: 02/12/2009 Req'd Qty: 2.00



Reference:

Approvals: Process Plan: PLDate: 09/11/23

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2841	Rev B

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2841-2 using D2622 extrusion as per Dwg D2842 □ 2-Drill extrusion per drawing D2842 using Jig DT 8265 □ 3-Deburr and bevel ends for welding

PL 09.11.242 f

110

QC5- Inspect part completeness to step on W/O

0.00

2/24/11

Memo

0.00

QC

Quality Control

(2) f

120

Large Fab

0.00

Large Fab

Memo

0.00

Large Fab

1-Weld end cap (AFT END ONLY) □ 2-weld lugs as per Dwg D2841 □ using Jig DT 8267 followed by DT8268 □ A/R AL ROD Batch: 11/13/11 □ 3-Grind end cap welds flushPL 09.11.252 f

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53924

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Setup Start



Revision ID: B

Stop



Item Name: Step Assembly RH, 206 Float

Start Date: 23/11/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 02/12/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID****Operation
Description**Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

ID 09.11.26

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

27 S oah/26

AA
27 S oah/26

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

H 09.11.26

2 S

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item Name: Step Assembly RH, 206 Float

Start Date: 23/11/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 02/12/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

**Sequence ID/
Work Center ID****Operation
Description**Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

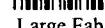
Quality Control

A 09/11/27

170

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

1-Inspect for foreign object per QSI 024 □2-Weld Remaining end cap as per Dwg D2841 □using Jig DT 8267 followed by DT 8268 □A/R AL ROD
Batch: M11/31 □3- grind end cap weld flush as per dwg D2841

M 09.11.27

180

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

4-Touch up with Alodine UNDO 09/11/30

P 09.11.30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D2841-042

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Item Name: Step Assembly RH, 206 Float

Start Date: 23/11/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 02/12/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00

27/11/09



QC

Quality Control

Memo

0.00

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

0.00

START TIME:

10:45

OVEN TEMPERATURE:

BL09-02-01

FINISH TIME:

11:15

210

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

MD 09/11/02

X2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 53924



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Item ID: D2841-042

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Stop



Item Name: Step Assembly RH, 206 Float

Start Date: 23/11/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 02/12/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220



HandFinishing

0.00

HandFinish

Memo

0.00

Hand Finishing

1-Install inserts as per Dwg D2842 2-Wing Walk as per Dwg D2842 and QSI
 005 4.1 Batch: m 112623 (wing walk)
 Sikaflex m 112345 exp: 10/08

W/O 09/11/02 ✓

230



QC5- Inspect part completeness to step on W/O

0.00

→ S 01.12.02

QC

Memo

0.00

Quality Control

INSPECT WORK/WING WALK

(✓) RH

240



Identify as per dwg & Stock Location:

0.00

PPP
52140

Packaging

Memo

0.00

PCG/12/17/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53924

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Item ID: D2841-042

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Setup Start



Revision ID: B

Stop



Item Name: Step Assembly RH, 206 Float

Start Date: 23/11/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 02/12/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/01

MMF 09-12-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 53924



Parent Item: D2841-042RevB



Parent Item Name: Step Assembly RH, 206 Float

Start Date: 23/11/2009

Required Date: 02/12/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN960C10L

Purchased

No

100

Each

2,604.000

8.0000

washer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

OFFSHORE

FG 100

103585 100

Main Warehouse

ST 2504

112116 548

112612 956

112933 1000

D2622-120CRevC1

Manufactured

No

120

Each

95.3200

2.0000

Step Extrusion

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

WA 95.32

48612 11.62

52026 83.7

X8 MO 09/12/02
10/11/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 53924



Parent Item: D2841-042RevB



Parent Item Name: Step Assembly RH, 206 Float

Start Date: 23/11/2009

Required Date: 02/12/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2734RevC



Manufactured

No

120

Each

39.0000

4.0000



11/09.11.25

Warehouse

Location

Main Warehouse

ST

Loc Qty

Loc Code

39

43535

2

48110

37

120

Each

32.0000

2.0000

D3464-1RevA



Manufactured

No

Warehouse

Location

Main Warehouse

ST

Loc Qty

Loc Code

32

37348

8

44607

24

120

Each

27.0000

2.0000



11/09.11.25

Float Step Mounting Plate



Warehouse

Location

Main Warehouse

ST

Loc Qty

Loc Code

27

37349

12

37791

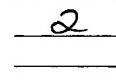
15

120

Each

27.0000

2.0000



11/09.11.25

D3464-3RevA



Float Step Mounting Plate



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 53924



Parent Item: D2841-042RevB



Parent Item Name: Step Assembly RH, 206 Float

Start Date: 23/11/2009

Required Date: 02/12/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3464-5RevA



Manufactured

No

120

Each

6.0000

2.0000



12/09.11.25

Warehouse

Location

Main Warehouse

ST

Loc Qty

Loc Code

6

25427

6

D3464-7RevA



Manufactured

No

220

Each

25.0000

2.0000



12/09.11.25

Warehouse

Location

Main Warehouse

ST

Loc Qty

Loc Code

25

25428

6

44608

19

MS27039C1-07



Purchased

No

220

Each

46.0000

8.0000



12/09.11.25

screw

Warehouse

Location

Main Warehouse

ST

Loc Qty

Loc Code

46

107008

1

111424

45



X8 MO 09/12/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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November 23, 2009 2:51:02 PM

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Parent Item: D2841-042RevB



Parent Item Name: Step Assembly RH, 206 Float

Start Date: 23/11/2009

Required Date: 02/12/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1329C3KB130		Purchased		No		220	Each	98.0000	8.0000			

insert

WarehouseLocation

Main Warehouse

ST

111981

Loc QtyLoc Code

98

98

X8 MD 09/12/02

NAS1515H3L

Purchased

No

220

Each

266.0000

8.0000

WASHER

WarehouseLocation

OFFSHORE

FG

Loc Qty

102472

40

X8 MD 09/12/02

Main Warehouse

ST

110450

226

111819

2

224

X8 MD 09/12/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

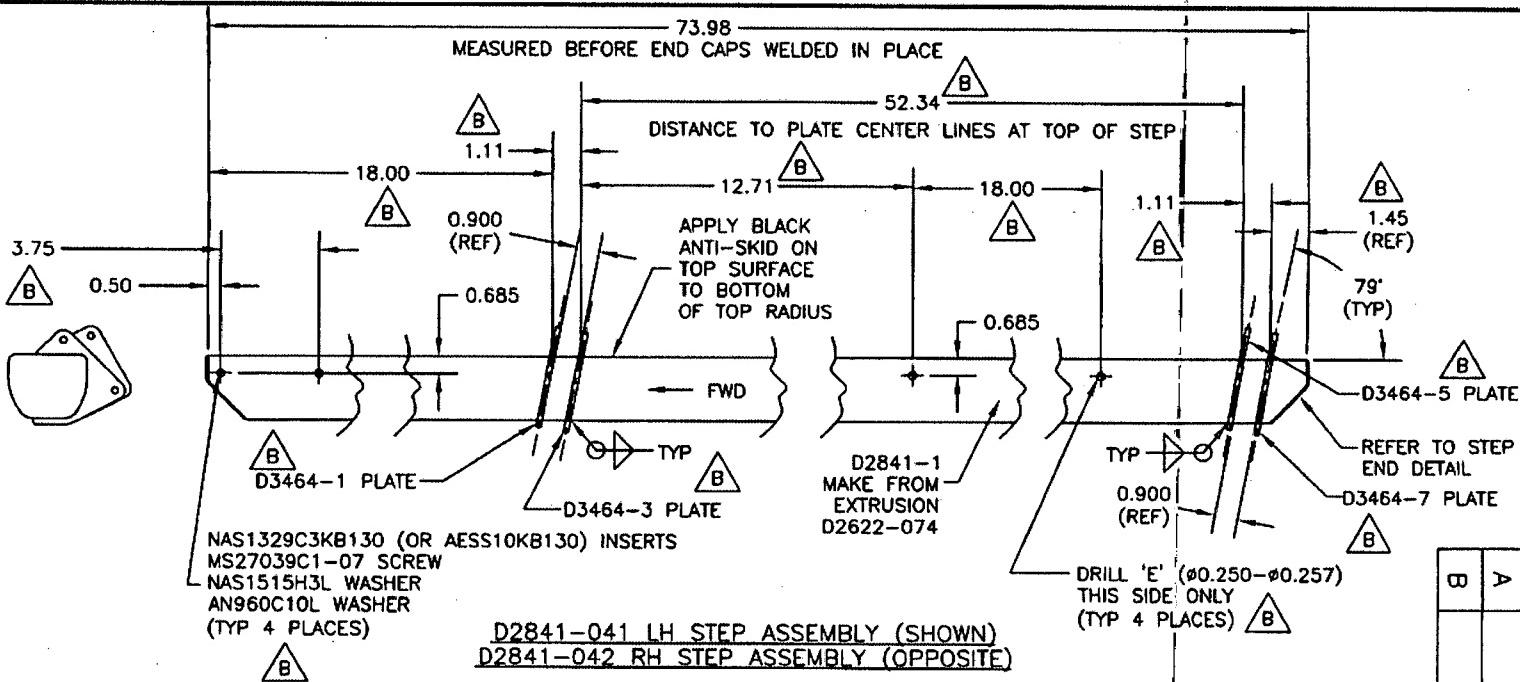
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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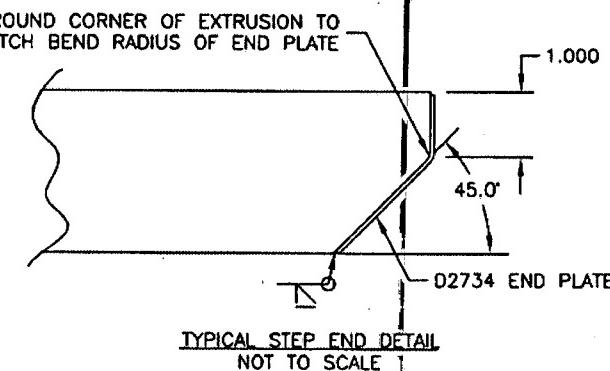
D2841-041/-042 STEP ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X		D2841-041	LH STEP ASSEMBLY
X		D2841-042	RH STEP ASSEMBLY
1	1	D2622-074	EXTRUSION
1	1	D3464-1	PLATE
1	1	D3464-3	PLATE
1	1	D3464-5	PLATE
1	1	D3464-7	PLATE
2	2	D2734	END PLATE
4	4	NAS139C3KB130 (OR AESS10KB130)	INSERT
4	4	MS2709C1-07	SCREW
4	4	NAS181SH3L	WASHER
4	4	AN980C10L	WASHER

**NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004**

D2841-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
 - 2) WELD PER DART QSI 004
 - 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
 - 4) ALL DIMENSIONS ARE IN INCHES
 - 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



TYPICAL STEP END DETAIL
NOT TO SCALE 1

RETURNED
ENGINEER G
UNCONTROLLED
SUBJECT TO AMENDMENT

KE		DRAWN BY <i>[Signature]</i>	DART AEROSPACE USA, INC.		
			PORT HADLOCK, WA		
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2841			REV. B
DATE 05.09.21		TITLE 206B FLOAT STEP ASSEMBLY			SHEET 1 OF 1
A	98.10.14	NEW ISSUE			SCALE NTS